



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3272-041
Job Sheet 206750



Part No: D3272-041

Job Qty: 2 pcs

Part Name: Step Assembly, High Long (LH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/20

Job Tracking No:

Due Date: ~~2/13/20~~ 18th Février

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Large Fab - Steps - 1	2 pcs			0.00	9.29	Large Fab - 1			
							Large Fab - 10			
							Large Fab - 2			
							Large Fab - 3			
							Large Fab - 4			
							Large Fab - 5			
							Large Fab - 6			
							Large Fab - 7			
							Large Fab - 8			
							Large Fab - 9			
							Large Fab - 11 (Various)			
							Large Fab - 12			
120	QC 9	2 pcs			0.00	0.00	QC 9 - 10			
							QC 9 - 18			
							QC 9 - 24			
							QC 9 - 43			
							QC 9 - 50			
							QC 9 - 9			
130	QC 5	2 pcs			0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			

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PRIORITY



Container No: S255503



Part: D3272-041

Job No: 206750

Serial No/Batch: S255503

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 02/13/20

Plex 2/7/20 10:27 AM Dart.lajeunesse.marie

140 Handfinish - 1-1 Chemical-B4B	2 pcs	0.00 0.57	QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 QC 7	2 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	

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DAS
43
9-88

160 Large Fab - Steps - 2 - B4B	2 pcs	0.00 9.29	QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	DAS
			Large Fab - 5 - B4B	43
			Large Fab - 6 - B4B	9-89
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 10	2 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	DAS
			QC 10 - 43	24
			QC 10 - 50	9-89
			QC 10 - 58	
			QC 10 - 9	
			QC 10 - 68	
			QC 5 - 10	
			QC 5 - 12	
180 QC 5	2 pcs	0.00 0.00	QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	DAS
			QC 5 - 24	24
			QC 5 - 3	9-89
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
190 Handfinish - 1-2- Chemical- B4B	2 pcs	0.00 0.57	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	

DAS
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Hand

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			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
200 Powdercoat - 1 White GI(A)- B4B	2 pcs	0.00 0.84	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-02-18.
			Powdercoat - 4 - B4B	
210 Handfinish - 3-1- WingWalk- B4B	2 pcs	0.00 0.57	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	FEB 20-02-18.
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
220 QC 3	2 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
230 Packaging 3-1 - Stock - B4B	2 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	

DAS 34 9-89

DAS 82

FEB 19 2020 9-89

DAS 69 9-89

FEB 19 2020

			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 37 - B4B	
240 QC 21 - SA	2 pcs	0.00 0.00	QC 21 - SA - 21	DAS FEB 19 2020
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-20

Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: M130137), 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M130137
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Weld per dwg A/R Aluminum rod Batch: M130137), 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Chemical Conversion Coat per QSI005 4.1) M25390
 200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: 11:00 OUT:320° FINISH: 1130
 210 - (Wing Walk as per dwg QSI005 4.4 Batch: 5240464)
 220 - (QC3- Inspect Part Finish)
 230 - (Identify as per dwg & Stock Location: _____)
 240 - (QC21- Final Inspection - Work Order Release)

MU#014406

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	110-Large Fab - Steps - 1	5243427 5243427
D3067-1	End Plate	2 pcs (1 ea)	110-Large Fab - Steps - 1	5246961
D3219-1	Plate	4 pcs (2 ea)	110-Large Fab - Steps - 1	5226808
D3065-041	Step Leg Assembly	2 pcs (1 ea)	160-Large Fab - Steps - 2 - B4B	5241887 5241887
D3066-1	Spacer	4 pcs (2 ea)	160-Large Fab - Steps - 2 - B4B	5225588
D3067-1	End Plate	2 pcs (1 ea)	160-Large Fab - Steps - 2 - B4B	5227588 5246961
MS20600-AD4W4	Rivet	32 Ea (16 ea)	160-Large Fab - Steps - 2 - B4B	5261801

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	2	115	0
	D3067-1	2	98	0
	D3219-1	4	124	0
160-Large Fab - Steps - 2 - B4B	D3065-041	2	14	0
	D3066-1	4	103	0
	D3067-1	2	98	0
	MS20600-AD4W4	32	3,619	0

Part Specifications

Specifications could not be found.

Plex 2/7/20 10:27 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			